Dart Aerospace Ltd.
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D3319-1
Job Sheet 192580

DAS 21 8-69

Part No: D3319-1 **Job Qty:** ~~12~~ 14 pcs

Part Name: Forward Wearplate

Part Weight: 0 lbs **Status:** New **Priority:** Medium

Job Created: 3/27/19 **Job Tracking No:**

Due Date: ~~4/17/19~~ MAY 3 **Created By:** Marie Lajeunesse

Type: Stock **Description:**

Note: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC IPP Rev:C Now on Waterjet 06-10-26 JLM IPP REV:D 17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
100	**Waterjet - Flow - 1**	12 pcs		4/17/19	0.00	1.25	Waterjet - Flow		DC 19/04/26
110	**QC 2**	12 pcs		4/17/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		DC 19/04/26
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

DART AEROSPACE

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Container No: S176059

Part: D3319 – 1
Job No: 192580
Serial No/Batch: S176059
Revision: D
Inspector:
Exp Date:
Instructions: Various STC's

Date: 05/01/19

					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
120	**QC 8**	12 pcs	4/17/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	DAS 40 9-89
					QC 8 - 40	APR 2 9 2019
					QC 8 - 52	
					QC 8 - 23	
140	**Small Fab - Brake NC - B4B**	12 pcs	4/17/19	0.00 0.87	Small Fab - Brake - 1 - B4B	DAS 30 9-89 APR 30 2019
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
150	**QC 5**	12 pcs	4/17/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	DAS
					QC 5 - 40	APR 3 0 2019 40 9-89
160	**Automated Welding - B4B**	12 pcs	4/17/19	0.00 3.08	Automated Welding - 1 - B4B	
170	**QC 10**	12 pcs	4/17/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
180	**QC 5**	12	4/17/19	0.00 0.00	QC 5 - 10	

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		pcs			QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	AL
					QC 5 - 30	
					QC 5 - 40	
190	**Spray Paint - 2 - B4B**	12 pcs	4/17/19	0.00 2.00	Spray Paint - 1 - B4B	AL 19-5-1
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
200	**QC 3**	12 pcs	4/17/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	DAS
					QC 3 - 40	MAY 0 2 2019 40
					QC 3 - 19	9-89
210	**Packaging 3-1 - Stock - B4B**	12 pcs	4/17/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	

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				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 **QC 21 - SA**	12 pcs	4/17/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS 21 MAY 02 2019
				QC 21 - SA - 53	

Part Op Descriptions:
100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary
110 - (QC2- Inspect parts off machine FAI/FAIB)
120 - QC8- Inspect parts - second check)
140 - (Form as per dwg) 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: _____ 2- Form flat on press using DT8776 block
150 - QC5- Inspect part completeness to step on W/O)
160 - 8259 HARDCOAT B: M38901
170 - (QC10- Inspect visual per QSI004- ground welds)
180 - (QC5- Inspect part completeness to step on W/O)
190 - Spray Paint / NDT Room) COAT ENTIRED TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE. BATCH: S156450
200 - (QC3- Inspect Part Finish)
210 - (Identify as per dwg & Stock Location:_____)Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location:_____
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	7.5360 sf (.628 ea)	100-Waterjet - Flow - 1	S123199

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	8	272	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	4.980inches ± 0.030	5.010 4.950		
2	Wearplate	1.600inches ± 0.010	1.610 1.590		
3	Wearplate	2.660inches ± 0.010	2.670 2.650		
4	Wearplate	3.190inches ± 0.010	3.200 3.180		
5	Wearplate	3.563inches ± 0.010	3.573 3.553		
6	Wearplate	4.710inches ± 0.030	4.740 4.680		
7	Wearplate	0.600inches ± 0.030	0.630 0.570		
8	Wearplate	10.576inches ± 0.010	10.586 10.566		
9	Wearplate	11.942inches ± 0.010	11.952 11.932		
10	Wearplate	18.090inches ± 0.030	18.120 18.060		
11	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315		
12	Wearplate	0.546inches ± 0.010	0.556 0.536		
13	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315		
14	Wearplate	0.670inches ± 0.010	0.680 0.660		
15	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189		
16	Wearplate	3.815inches ± 0.010	3.825 3.805		
17	Wearplate	16.100inches ± 0.010	16.110 16.090		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

DART AEROSPACE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :	Sequence #:	QTY Affected :	MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced
☐ Bending
☐ Crushing
☐ Cracks
☐ Crimp/Kink/Ripple/Wave/Twist
☐ Marks/Chatter
☐ Mislabeled
☐ Contamination
☐ Misaligned/off center
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Incomplete/Unclear Instructions
☐ Drill Holes
☐ Fit/Function
☐ Power Loss/Surge
☐ Folio/Program
☐ Grain Direction
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set/Set-up
☐ Positioned Wrong
☐ Outside Tolerance
☐ Drawing
☐ Finish
☐ Part Lost/Missing
☐ Misread

Other/Details:

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Container No: S176059

Part: D3319-1
Job No: 192580
Serial No/Batch: S176059
Revision: D
Inspector:
Exp Date:
Instructions: Various STC's

Date: 04/29/19